

# Work Order ID 85083

June-01-12 3:19:43 PM

**\*85083\***

Page 1

Item ID: D3065-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Leg Assembly Hi

Start Date: 01/06/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/12* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

*30x*

*12/07/12*

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*12/07/12*

120

Identify as per dwg & Stock Location: *W/A*

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

*Step Cell*

*30*

*φ*

*12.07.30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85083****\*85083\***

Page 2

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Item ID: D3065-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step Leg Assembly Hi

Start Date: 01/06/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 08/06/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/7/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

June-01-12 3:19:48 PM

Page 1

Work Order ID: 85083

**\*85083\***

Parent Item: D3065-041

**\*D3065-041\***

Parent Item Name: Step Leg Assembly Hi

Start Date: 01/06/2012

Required Date: 08/06/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1		Manufactured	No			100	Each	142.0000	1	30			
<b>*D3065-1*</b>									<b>**</b>				
Step Spacer													

Location	Loc Qty	Loc Code
GA	142	
74497	1	
81303	1	
81304	36	
83733	52	
83872	52	

*4512/07/12*

*228*

D3065-3

Manufactured No

100 Each 142.0000 1

30

**\*D3065-3\***

**\*\***

Step Spacer

Location	Loc Qty	Loc Code
GA	142	
69827	1	
73290	4	
75152	14	
81306	10	
83734	50	
83873	63	

*4512/07/12*

*30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 85083

**\*85083\***

Parent Item: D3065-041

**\*D3065-041\***

Parent Item Name: Step Leg Assembly Hi

Start Date: 01/06/2012

Required Date: 08/06/2012

Start Qty: 30.00

Required Qty: 30.00

D3065-5

Manufactured No

100 Each 220.0000 2 60

**\*D3065-5\***

Step Leg

\*\*

*EP 12/07/12*

Location

Loc Qty

Loc Code

GA	220
67222	1
73289	19
83736	100
83874	100

*B85462*  
*(200)*

D3065-7

Manufactured No

100 Each 131.0000 1 30

**\*D3065-7\***

Step Spacer

\*\*

*EP 12/07/12*

Location

Loc Qty

Loc Code

GA	131
73291	7
74499	1
78666	4
81310	22
83738	48
83875	49

*30*

MS20470AD4-4

Purchased No

100 Each 6,315.000 30 900

**\*MS20470AD4-4\***

Rivet, Universal Head

\*\*

*EP 12/07/12*

Location

Loc Qty

Loc Code

ST319	6315
116188	136
116391	66
118614	1046
119109	26
120361	36
121011	5
121556	2000
121652	3000

*M122063*  
*(9000)*

June-01-12 3:19:48 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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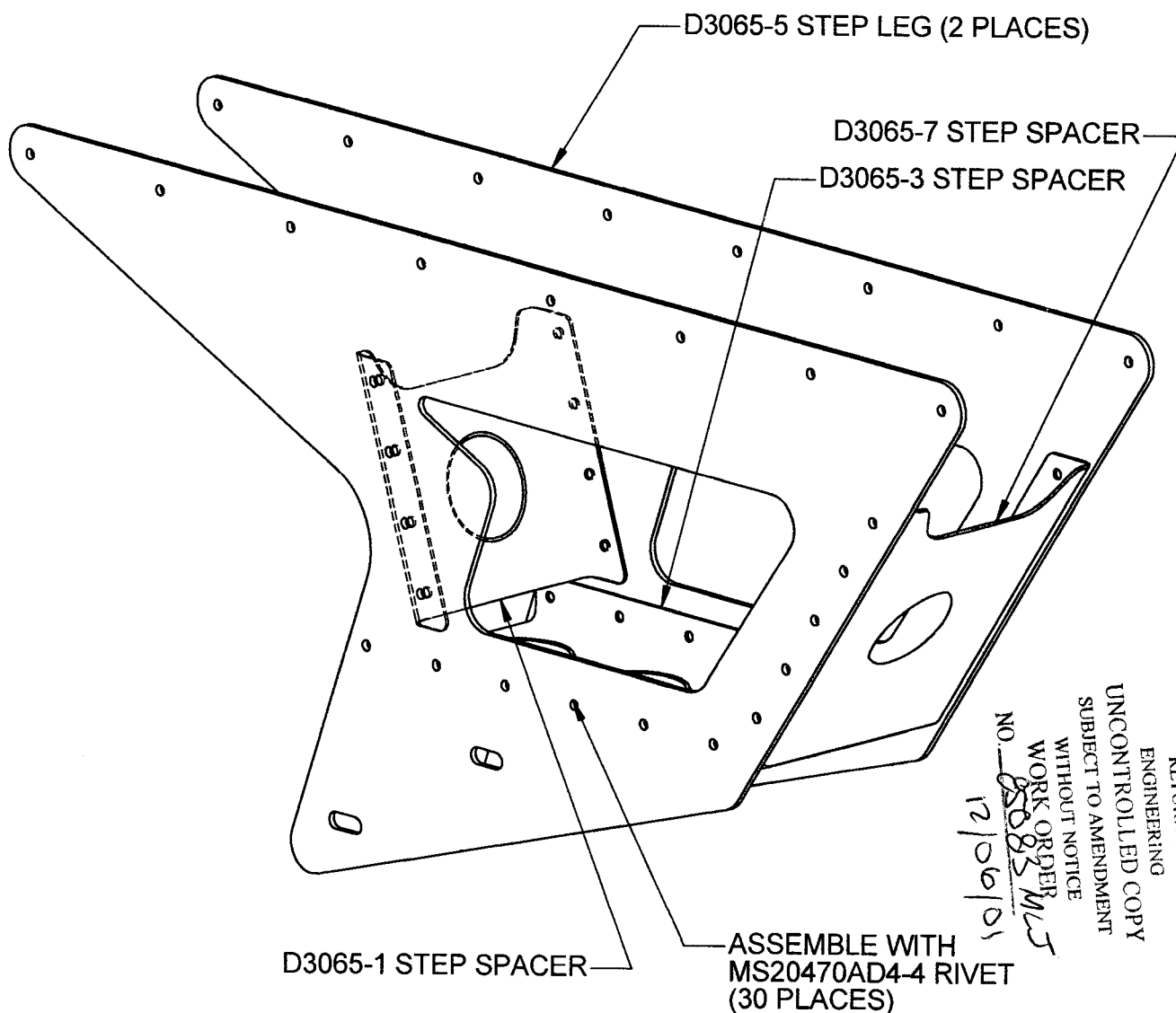




DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

*06.06.20* *[Signature]*



## D3065-041 STEP LEG ASSEMBLY

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# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

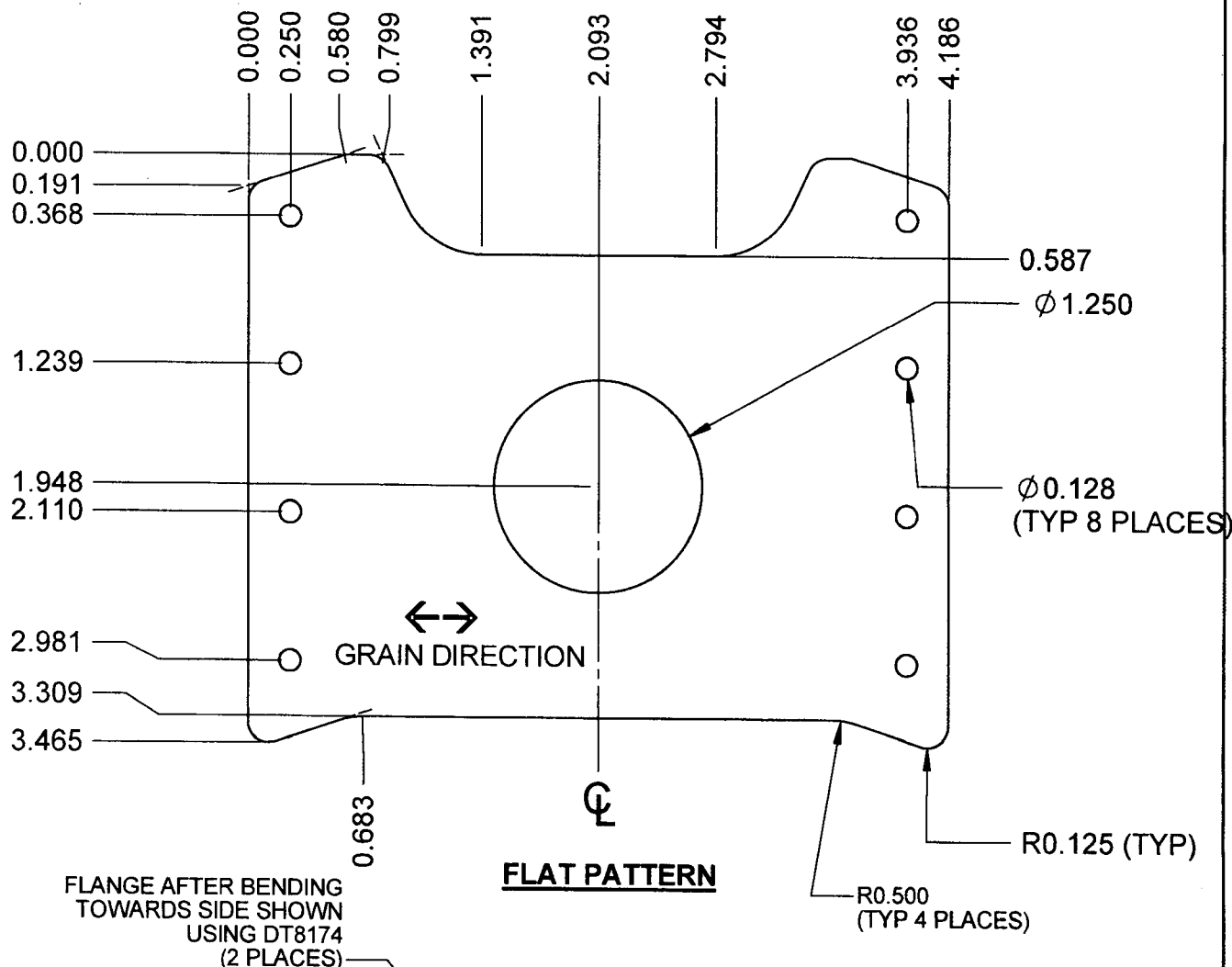
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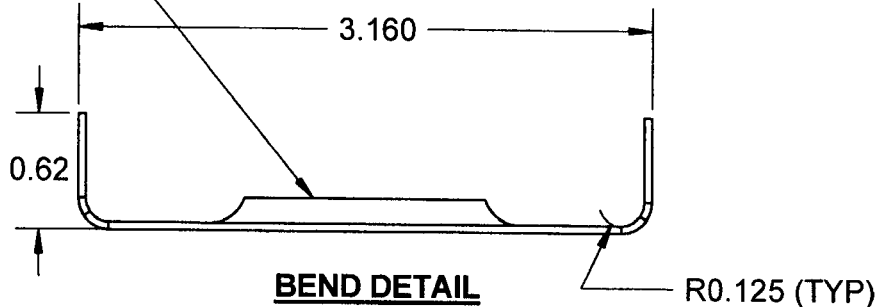


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



RELEASED

*CP de 20*



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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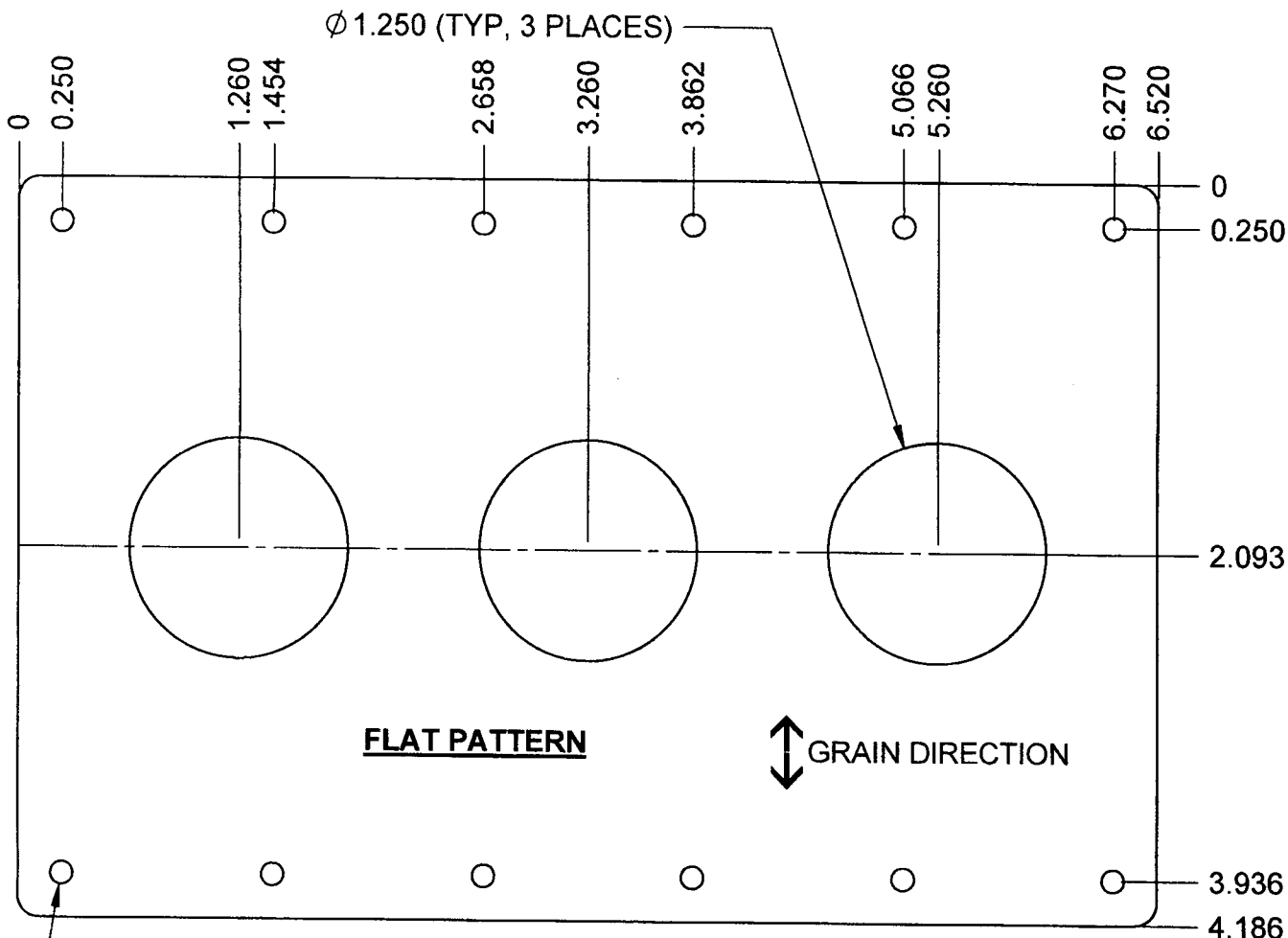
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DESIGN <i>UP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SHEET 3 OF 5 SCALE 1:1

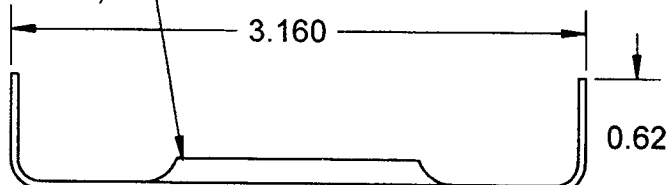


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

$\phi 0.129$  (TYP, 12 PLACES)

**RELEASED**

*06 ok 20*



**BEND DETAIL**

### D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# Dart Aerospace Ltd

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



REV. B  
SHEET 4 OF 5  
SCALE  
1:3



- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"  
 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
 (REF DART SPEC M6061T6S.080)  
 OR  
 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)  
 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 6) ALL DIMENSIONS ARE IN INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

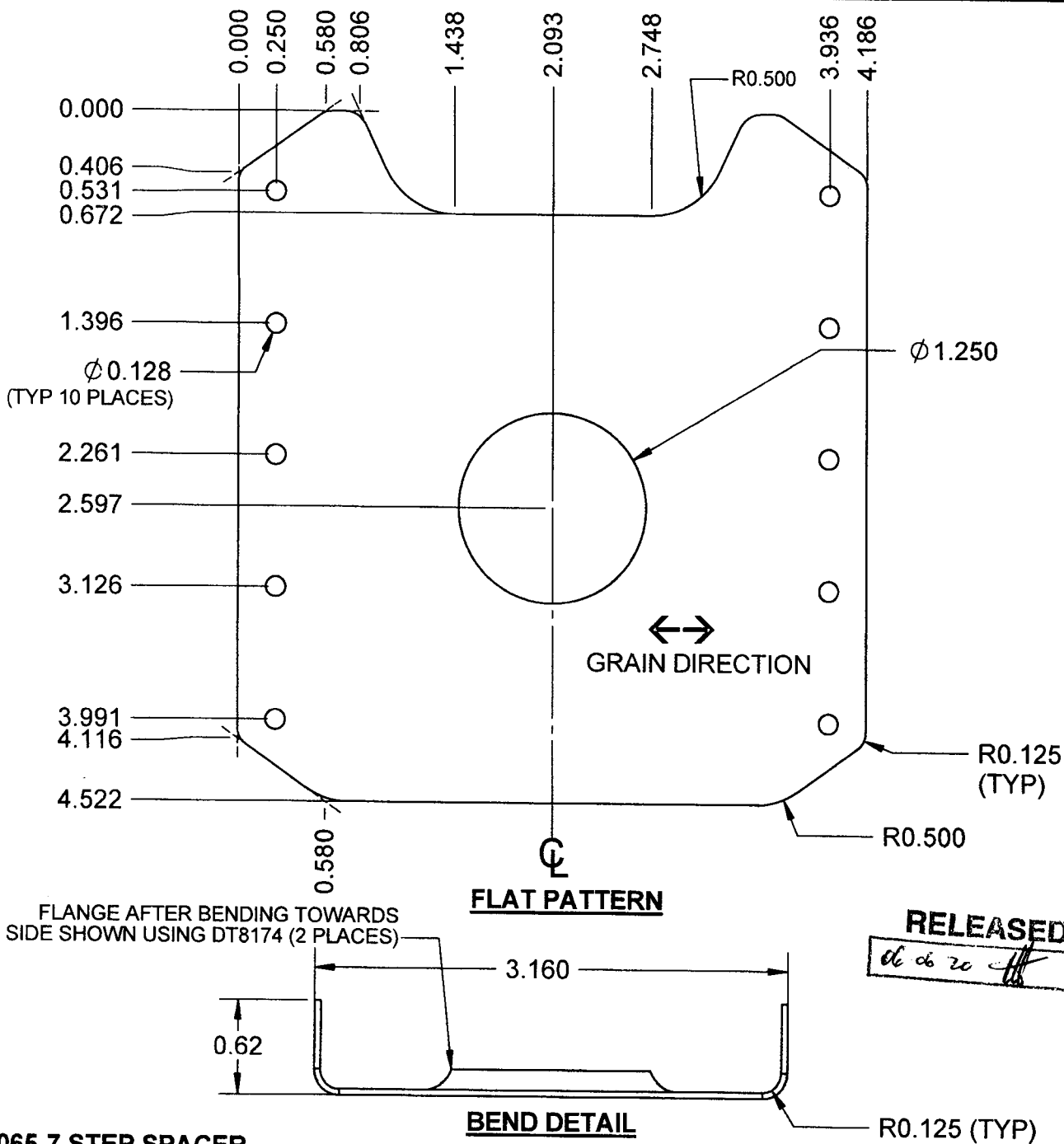
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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05083

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